

Work Order ID 115197

Thursday, March 20, 2014 9:19:05 AM

115197

Page 1

Item ID: D3910-5

Revision ID:

Item Name: Crosstube Lug

Start Date: 3/13/2014 Start Qty: 80.00

Required Date: 3/28/2014 Req'd Qty: 80.00

Reference:

Approvals: Process Plan: CL Date: 14/03/20 Tooling:

QC: Date: SPC (Y/N):

N9000040100

Cust Item ID:

Customer:

Setup Start ***NS1***

Stop ***NS2***

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3910	D
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110 Outsource process - Machining 0.00

110

Outsource5

Outsource process - Machining

HAAS CNC VERTICAL MACHINING #1

Memo meter 0.00

Issue P/O to ATG 23468
MANUFACTURE AS PER DWG
C of C is required

CL 14/03/21 80

120 Receive & Inspect for Damage & Mat'l Certs 0.00

120

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo 0.00

Ensure C of C is attach

14/3/28 (su)

130 QC6- Inspect dimensions to drawing 0.00

130

QC

Quality Control

Memo 0.00

DAS

27

9-89

14/3/28

80
can

Chemical Can.
QC7

Powder Coat White Gloss M125027
QC3

DAS

27

9-89

14/4/11

80 14/3/31

80 14-4-4.

80 14-4-1.

DAS

34

9-89

34

9-89

Work Order ID 115197

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Item ID: D3910-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Lug
Start Date: 3/13/2014 Start Qty: 80.00 ***80*** Cust Item ID:
Required Date: 3/28/2014 Req'd Qty: 80.00 ***80*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>ST465</u>	0.00			DAS				
180					28				
Packaging	Memo	0.00			9-89				
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

14-04-2
14-04-02

Picklist Print

Page 1

Thursday, March 20, 2014 9:19:05 AM

Work Order ID: 115197

115197

Parent Item: D3910-5

D3910-5

Parent Item Name: Crosstube Lug

Start Date: 3/13/2014

Required Date: 3/28/2014

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
13.09.26 AS PER REV.D DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2423		Manufactured	No			100	f	213.6668		11			
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D2423

Lug Extrusion

CLY/03/21

Location

Loc Qty

Loc Code

HALL

213.666848

105422

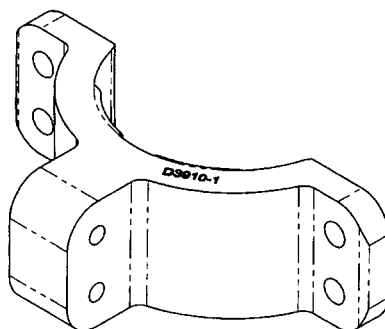
213.666848

11

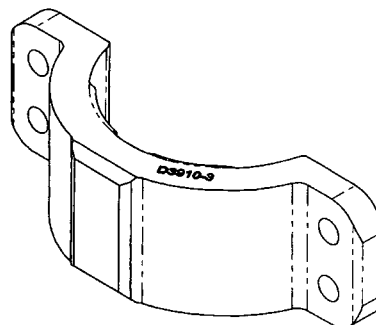
D3910-SP

x80

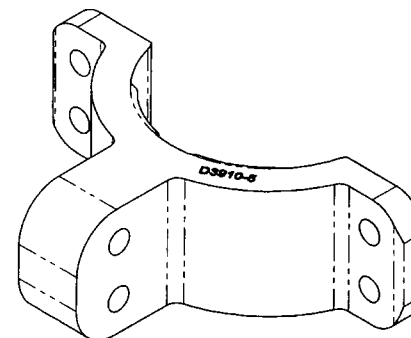
Rev/3/28



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs

115197

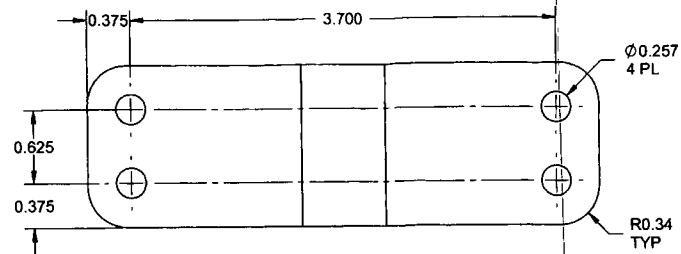
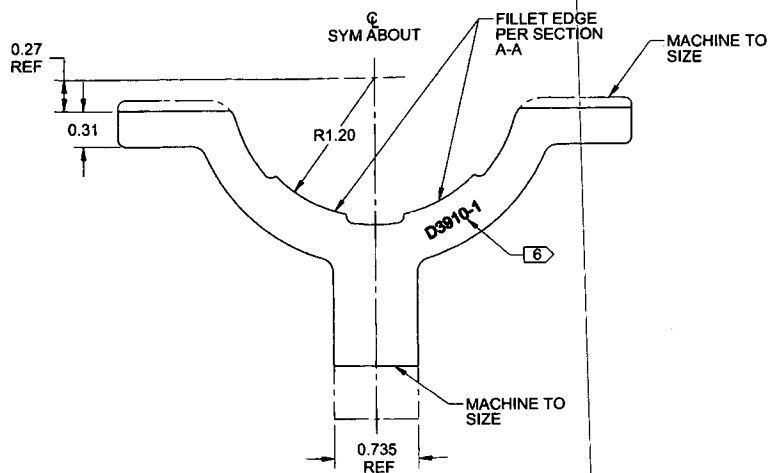
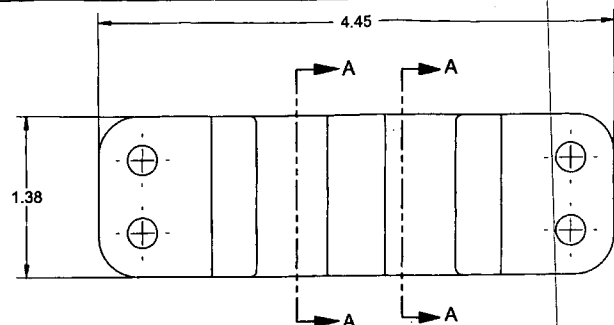
RELEASED
2013-09-23

D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	21	D3910	SHEET 1 OF 4
APPROVED	21	TITLE	SCALE
DE APPR.	21	X-TUBE LUG (350)	NTS
DATE	13.08.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

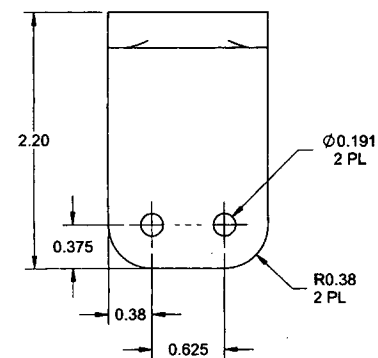


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG



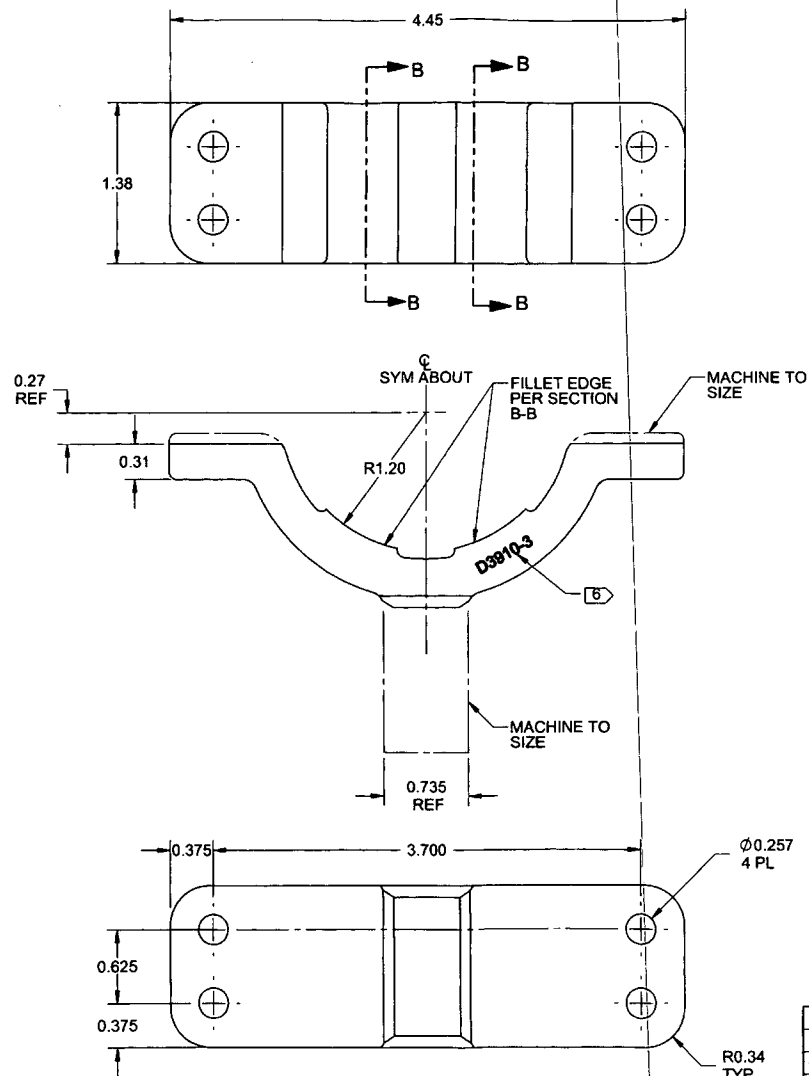
RELEASED
2013-09-23
MP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	2/	D3910	SHEET 2 OF 4
APPROVED	1/0	TITLE	SCALE
DE APPR.	5/1	X-TUBE LUG (350)	NTS
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SECTION B-B



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-3 X-TUBE LUG

RELEASED
2013-09-23
ND

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	2/	D3910	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	#	X-TUBE LUG (350)	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23468

Purchase Order Date 3/21/2014

PO Print Date 3/21/2014

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FORMED
08/14/03/21

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3910-5P	Crosstube Lug	4/4/2014 Yes 4/4/2014		80.00 Each	\$31.55	\$2,524.00
AS PER DWG D3910 REV.D B115917							

Line Total: \$2,524.00

2	71401-45	PROCUREMENT QUALITY CLAUSES	4/4/2014		1.00	\$0.00	\$0.00
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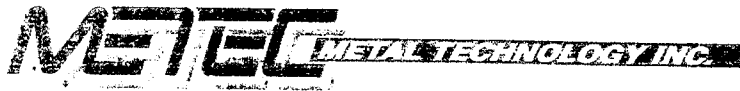
No

4/4/2014

Procurement Quality Clauses
A004 faa-pma/tso
A005 right of entry
A007 first article inspection
A016 personnel qualification
A026 certification of materila conformance
A040 notification of escape clauses
A042 dart notification by supplier
A043 retention of quality document

Note:

3/21/2014



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18372
Date: Mar 26, 2014
Page: 1

Sold to: Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 23468	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-5P Crosstube Lug as per DWG D3910 REV. D	Each	80	80	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:


same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
80	D3910-5P	Crosstube Lug	23468

MATERIAL: supplied by DART B105422

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, March 26, 2014